



Dart Aerospace Ltd.
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D4151-5
Job Sheet 192410



Part No: D4151-5

Job Qty: 20 pcs

Part Name: Fwd Basket Instl Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 4/19/19

Description:

Type: Stock

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Doosan - 1	20 pcs	4/19/19	4/19/19	0.00	6.41	Doosan - 1		
130	QC 8	20 pcs	4/19/19	4/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	20 pcs	4/19/19	4/19/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S173637



Part: D4151-5

Job No: 192410

Serial No/Batch: S173637

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 04/18/19

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	7080
				Packaging 3 - 28 - B4B	50
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA				QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 110 - (Doosan Lathe)1-Mill as per folio FA953 & dwg , Descriptions: 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location:_____) 150 - (QC21- Final Inspection - Work Order Release)					APR 24 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	5 ft (.25 ea)	110-Doosan - 1	5167683
				5167683

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Doosan - 1	M303R1.000	5	25	0

45.5"
 48"
 Total
 93.5
 19.25
 Total → 74.25"
 = 618 FT

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Basket Inst. Stud (Lower)	1.000Inches ± 0.030	1.030 0.970	Diameter	1.000
2	Fwd Basket Inst. Stud (Lower)	0.800Inches $+ 0.000$ $- 0.010$	0.800 0.790		0.7975
3	Fwd Basket Inst. Stud (Lower)	0.750Inches $+ 0.030$ $- 0.000$	0.780 0.750		0.7625
4	Fwd Basket Inst. Stud (Lower)	0.375Inches ± 0.010	0.385 0.365		0.375
5	Fwd Basket Inst. Stud (Lower)	0.500Inches ± 0.030	0.530 0.470		0.500
6	Fwd Basket Inst. Stud (Lower)	1.000Inches $+ 0.003$ $- 0.000$	1.003 1.000		1.0015
7	Fwd Basket Inst. Stud (Lower)	2.000Inches ± 0.030	2.030 1.970		1.986
8	Fwd Basket Inst. Stud (Lower)	2.880Inches ± 0.030	2.910 2.850		2.8715
9	Fwd Basket Inst. Stud (Lower)	0.250Inches ± 0.010	0.260 0.240		0.244
10	Fwd Basket Inst. Stud (Lower)	0.438Inches $+ 0.000$ $- 0.010$	0.438 0.428	Diameter	0.434
11	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100		0.1275
12	Fwd Basket Inst. Stud (Lower)	0.060Inches ± 0.030	0.090 0.030	Radius	0.0625 1/16 ok
13	Fwd Basket Inst. Stud (Lower)	0.250Inches $+ 0.003$ $- 0.000$	0.253 0.250	Diameter	0.250
14	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	Radius	1/8 ok

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					